

Work Order ID 73315

Wednesday, August 31, 2011 10:49:56 AM

Page 1

Item ID: D3535-15

Accept

Revision ID:

Item Name: Wearshoe

Start Date: 9/1/2011 Start Qty: 12.00

Required Date: 9/15/2011 Req'd Qty: 12.00

Reference:

Approvals:

Process Plan: ME

Date: 11-09-11

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3535

Rev B

100

0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3535

Dwg Rev: D

Prog Rev: D

□2-

Deburr if necessary

364.046

B11-9-19

(13)

110

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

B11-9-19

120

0.00



QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

8/10/11

count
(13)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73315

Wednesday, August 31, 2011 10:49:56 AM



Page 2

Item ID: D3535-15

Accept



Setup Start



Revision ID:

Item Name: Wearshoe

Stop



Start Date: 9/1/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 9/15/2011 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130

0.00



Brake NC

NC BRAKE

Memo

0.00

Brake NC

1-Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326 2-Form joggle as per Dwg D3535 using Jig DT8158 3-Identify as D3535-15

SB 11/09/19

13

140

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

5/10/19

+13

150

0.00



Powdercoat

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

Memo

0.00

Powder Coating

START TIME: 12:00 OVEN TEMPERATURE:

FINISH TIME: 12:30

32001

12:30

13x Ø M-f 11/09/20

M 11/23/38

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Work Order ID 73315

Wednesday, August 31, 2011 10:49:56 AM



Page 3

Item ID:	D3535-15	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Wearshoe					
Start Date:	9/1/2011	Start Qty:	12.00		Cust Item ID:	
Required Date:	9/15/2011	Req'd Qty:	12.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 	QC3- Inspect Part Finish	0.00							
QC Quality Control	Memo	0.00							13.0 11/09/20 canon
170 	Identify as per dwg & Stock Location:	0.00							
Packaging Packaging	Memo	0.00							13x 11/09/20
180 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							11/9/21 ME 11-09-21

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Wednesday, August 31, 2011 10:49:53 AM

Page 1

Work Order ID: 73315



Parent Item: D3535-15



Parent Item Name: Wearshoe


Start Date: 9/1/2011

Required Date: 9/15/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-02-15 JLM
IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA 		Purchased	No			100	sf	212.4072	1.0205	12.89053	13.5	8-11-9-19	

304/316 .040 Sheet

Location

Loc Qty

Loc Code

MAT020

212.4072

116623

0.2

117550

9.363

117933

79.3442

118400

123.5

118400

(13)

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	733151
Description: Wearshoe		Part Number:	D3535-15
Inspection Dwg: D3535	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.885	+/-0.010	1.889	✓		V 1802	
2.000	+/-0.010	2.000	✓		V	
5.650	+/-0.010	5.650	✓		T 1801	
9.150	+/-0.010	9.150	✓		T	
14.400	+/-0.010	14.400	✓		T	
19.650	+/-0.010	19.650	✓		T	
24.900	+/-0.010	24.900	✓		T	
30.150	+/-0.010	30.150	✓		T	
33.650	+/-0.010	33.650	✓		T	
35.650	+/-0.010	35.650	✓		T	
39.150	+/-0.010	39.150	✓		T	
Ø0.188	+0.005/-0.001	.191	✓		V	
24.00	+/-0.030	24.00	✓		T	
16.00	+/-0.030	16.00	✓		T	
8.00	+/-0.030	8.00	✓		T	
5.00	+/-0.030	5.00	✓		T	
0.300	+/-0.010	.301	✓		V	
0.300	+/-0.010	.302	✓		V	
0.038	+/-0.010	.037	✓		V	

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 11-9-19	Date: 11/9/19	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.10	New Issue	KJ/JLM	B

W/O:		WORK ORDER CHANGES					
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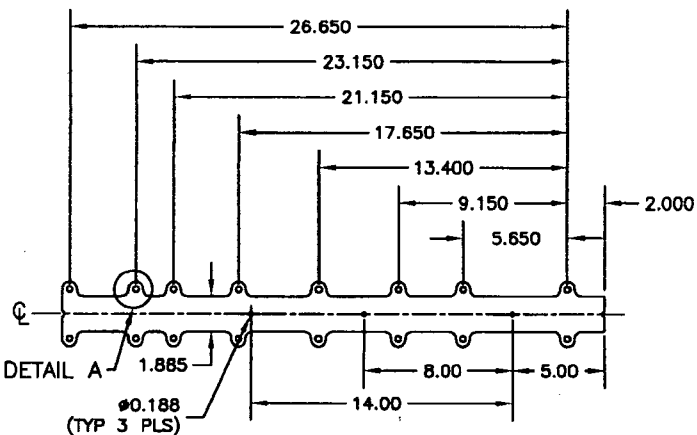
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DART

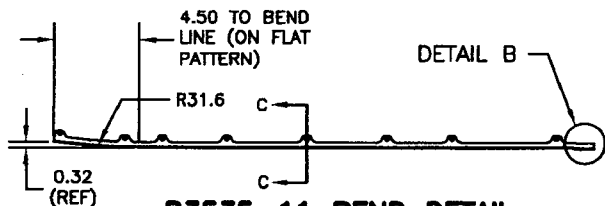
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07.04.17

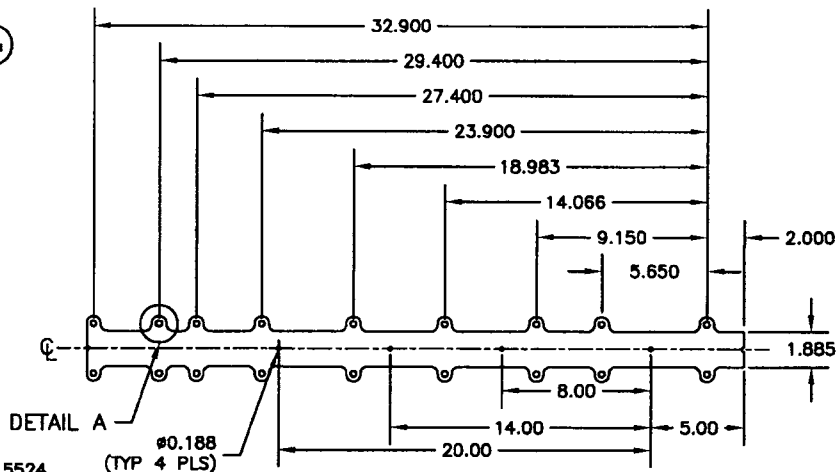
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CB	PH	PORT HADLOCK, WA		
CHECKED	APPROVED	DRAWING NO.	REV. B	
		D3535	SHEET 1 OF 7	
DATE	TITLE	SCALE		
07.04.17	WEARSHOE	1:1		
A	06.10.25	NEW ISSUE		
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC		



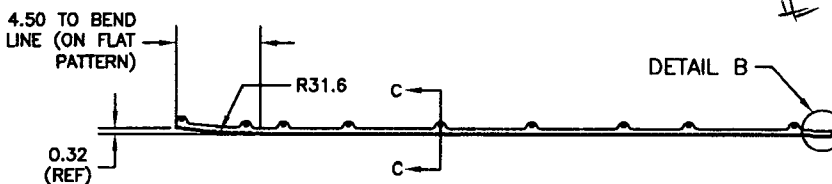
D3535-11F FLAT PATTERN



D3535-11 BEND DETAIL



D3535-13F FLAT PATTERN



D3535-13 BEND DETAIL

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

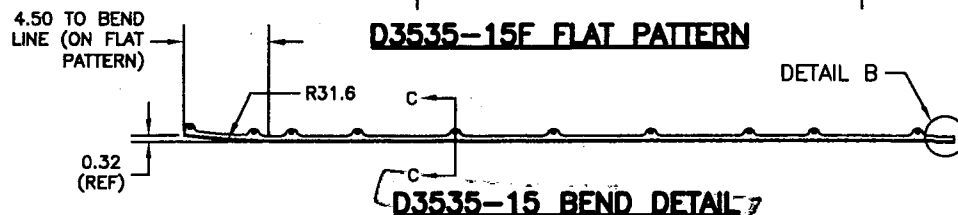
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED



07-09:24 #



- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524,
20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER
QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT
PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

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DESIGN C.B.	DRAWN BY P.H.	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED 	APPROVED 	DRAWING NO. D3535	REV. B SHEET 2 OF 7
DATE 07.04.17	TITLE WEARSHOE SCALE 1:10		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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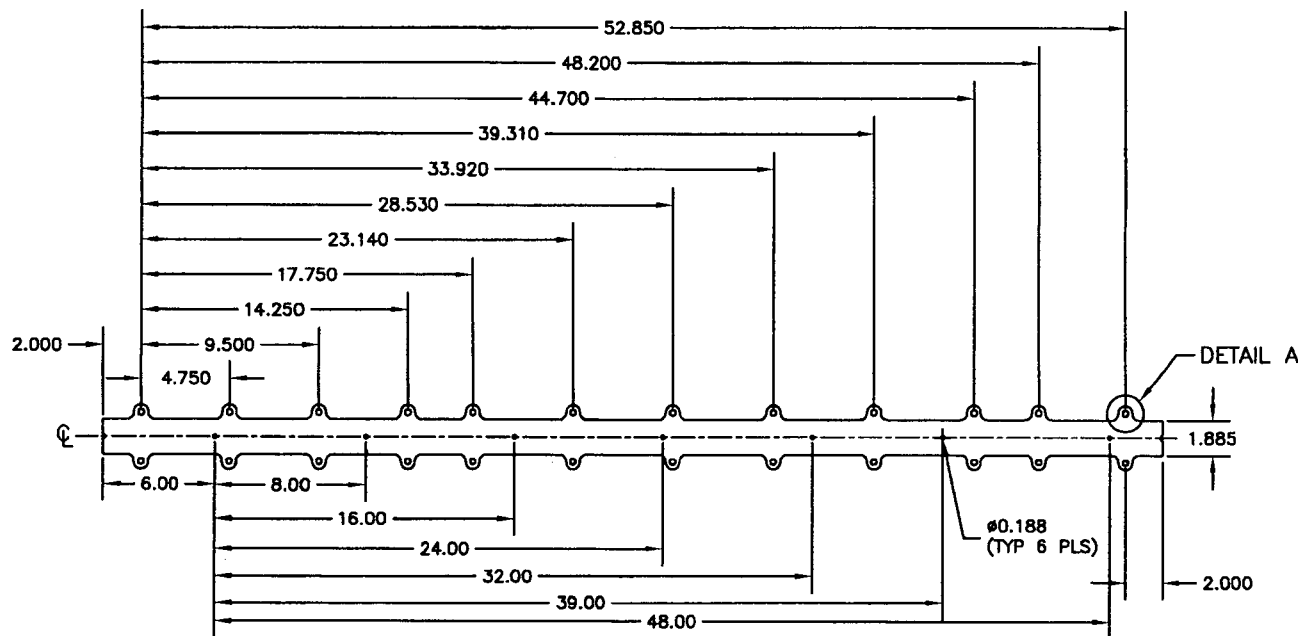
NOTE: Date & initial all entries

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07.04.24

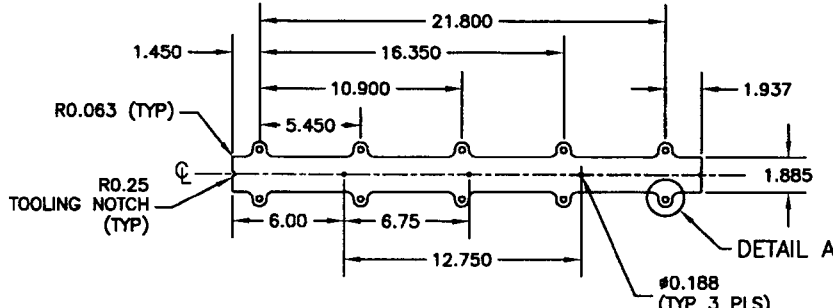
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CHECKED		APPROVED		PORT HADLOCK, WA
DATE	07.04.17	TITLE	D3535	WEARSHOE
		REV. B	SHEET 3 OF 7	SCALE 1:10



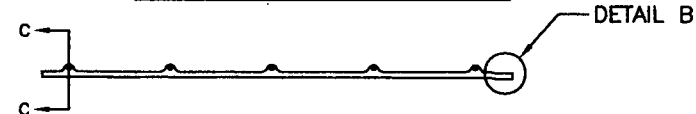
D3535-23F FLAT PATTERN



D3535-23 BEND DETAIL



D3535-25F FLAT PATTERN



D3535-25 BEND DETAIL

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

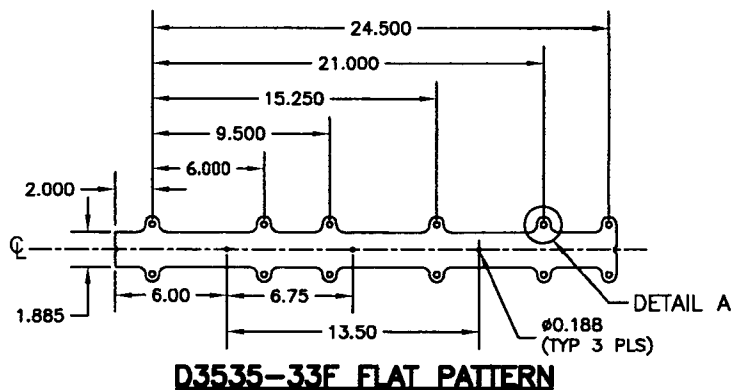
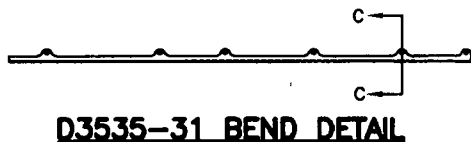
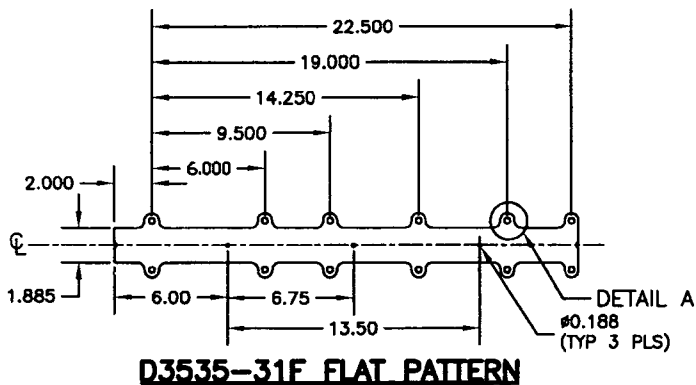
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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07.04.29



NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
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DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
CB	PH	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. B
		D3535	SHEET 4 OF 7
DATE	TITLE	SCALE	
07.04.17	WEARSHOE	1:10	

73315

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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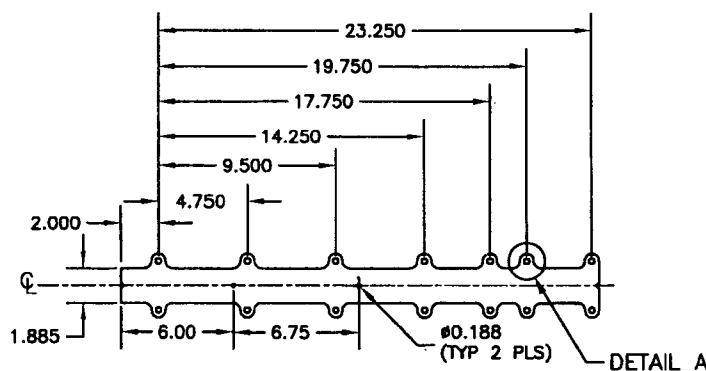
NOTE: Date & initial all entries

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07.04.17

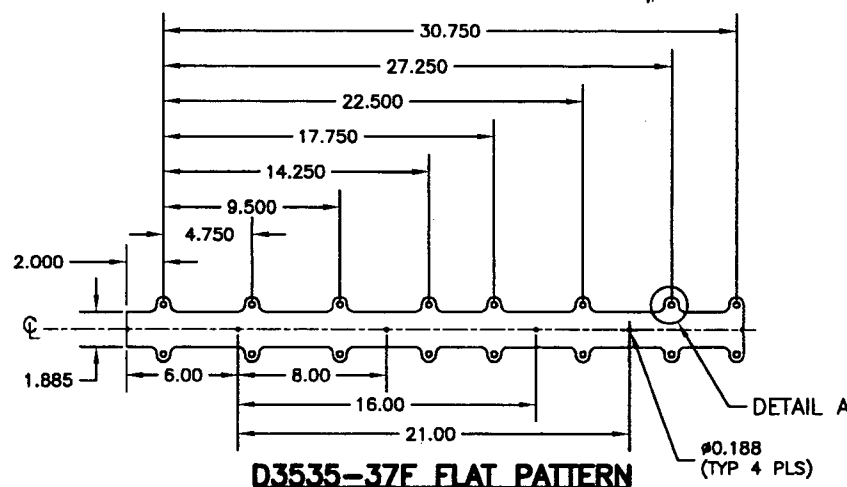
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DATE	07.04.17	TITLE	D3535	WEARSHOE
		SCALE	1:10	
		SHEET 5 OF 7		
		REV. B		



D3535-35F FLAT PATTERN



D3535-35 BEND DETAIL



D3535-37F FLAT PATTERN



D3535-37 BEND DETAIL

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.036 THICK)
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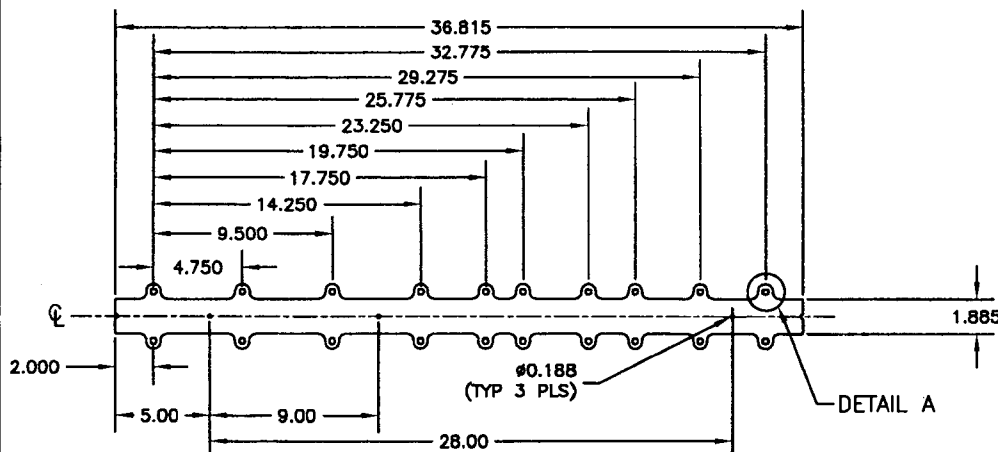
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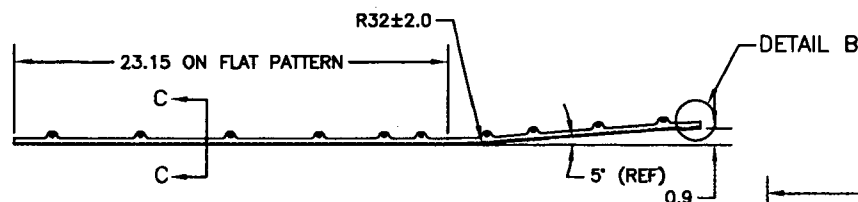
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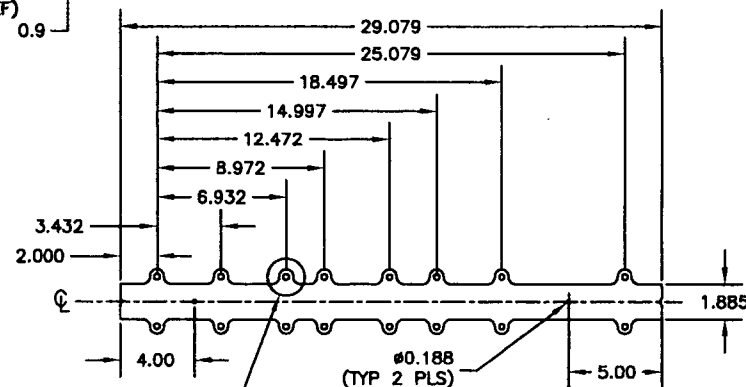
DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	REV. B
CB	PH	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	SHEET 6 OF 7
		D3535	
DATE	TITLE	SCALE	
0704.17	WEARSHOE	1:10	



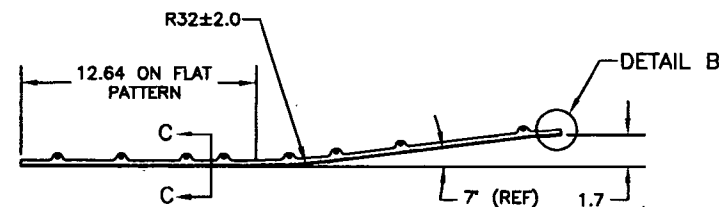
D3535-39F FLAT PATTERN



D3535-39 BEND DETAIL



D3535-41F FLAT PATTERN



D3535-41 BEND DETAIL

NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
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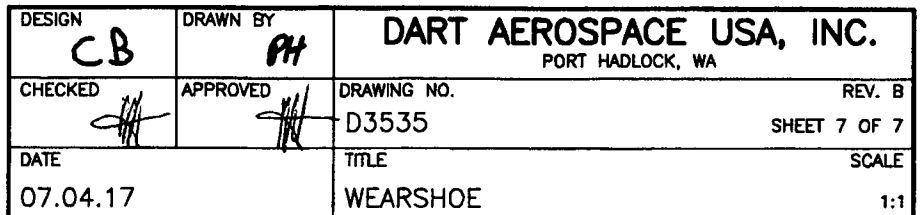
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

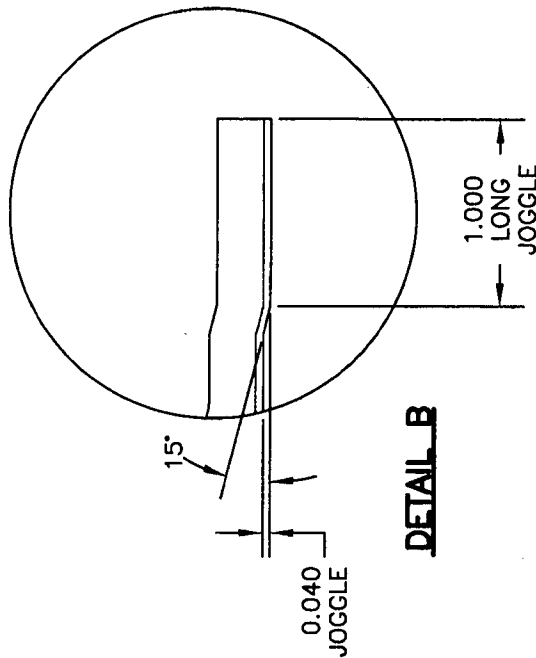
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

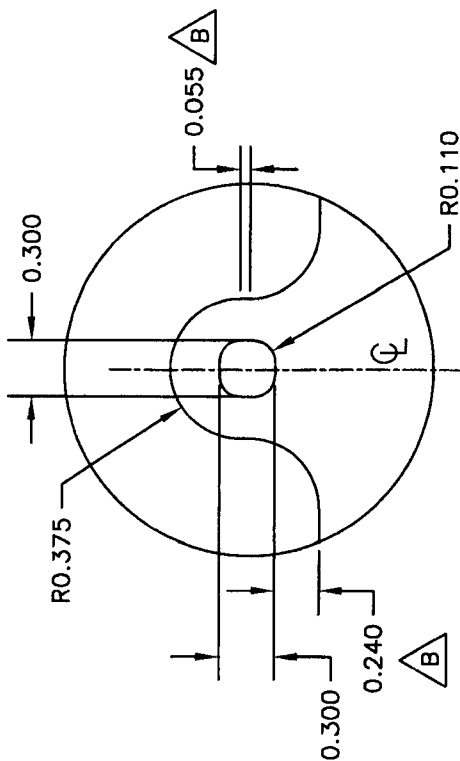


07.04.24

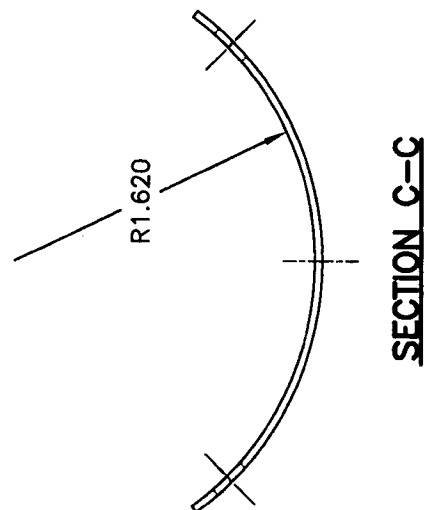


DETAIL B

73315



DETAIL A



SECTION C-C

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries